

Work Order ID 76375

76375

Page 1

November-11-11 9:17:05 AM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 11/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 18/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2571	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>76375</u> Double check by: <u>[Signature]</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect								

110	CONVENTIONAL MILLING MACHINE	0.00							
110									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2571 & D2572								

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11-11-23		6			
--	---	--------------	----	----------	--	---	--	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6			BR 11-11-23
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150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:15 FINISH TIME: 10:45	0.00 0.00							6xØ M-L 11/11/23
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W118434

3200F

10-45

Dart Aerospace Ltd

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November-11-11 9:17:05 AM

76375

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Item ID: D2571

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd Out 205

Start Date: 11/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>432</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

6 BL 11-11-23.

11/11/23 (6)

11/11/23 (18)

ME
11-11-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

November-11-11 9:17:12 AM

Page 1

Work Order ID: 76375

76375

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 11/11/2011

Required Date: 18/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	57.0000	1	6			

D6101-007

Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71722

8

MAT042

10

72228

2

→ 73421

8

MAT045

39

65383

1

65954

4

70680

6

73421

8

74781

20

6 and 11/11/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	76375
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.506	.502	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.250	.251	.251		
S	0.115	0.135		.132	.132	.131	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.237	.239	.239	.240		
W	0.115	0.135		.121	.120	.124	.122		
X	0.308	0.313		.311	.311	.312	.311		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.368	.367	.368	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.631	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.248	.249		
AE	1.375	1.395		1.3885	1.388	1.389	1.387		
AF	0.115	0.135		.132	.132	.132	.132		
AG	0.240	0.280		.260	.260	.255	.255		
AH	0.240	0.260		.249	.248	.248	.250		
AI	2.000	2.020		2.002	2.003	2.0035	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	CHZ
Date:	11/11/15

Audited by:	SL
Date:	11-11-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76315
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	


Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.005				
F	0.490	0.510		.506	.497				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.377				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.568	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.257	.257				
S	0.115	0.135		.134	.133				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.241	.240				
W	0.115	0.135		.122	.123				
X	0.308	0.313		.311	.311				
Y	0.760	0.765		.762	.762				
Z	0.352	0.372		.366	.366				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.243	.246				
AE	1.375	1.395		1.386	1.387				
AF	0.115	0.135		.132	.131				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.250	.249				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									






Measured by:	amf
Date:	11/11/22

Audited by:	Sh
Date:	11-11-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06 




MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

E

Technical drawing of a mechanical part showing a cross-section. The drawing includes the following dimensions and features:

- Top Surface:**
 - Left side: $0^{+0.005}_{-0.000}$
 - Center: **VIEW B-B** with a width of 1.73 and a depth of 0.20 .
 - Right side: $R0.66$ (TYP) and $R0.50$ (TYP).
- Internal Features:**
 - A central **DART** feature.
 - A feature labeled with a triangle containing the number **2**.
- Bottom Surface:**
 - Left side: 1.750 ± 0.005
 - Center: 3.500 ± 0.005
 - Right side: 1.750 ± 0.005
 - Total width: 8.000
- Other Features:**
 - Four circular features (holes) are shown along the bottom edge.

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR.. 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DRAWN BY PH		
CHECKED 	APPROVED 	DRAWING NO. D2571
DATE 05.07.13	TITLE OUTER FWD SADDLE	
		REV. 1 OF 2
		SCALE

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SCALE 4:3

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 763751

11/11/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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